

Work Order ID 61433

Wednesday, August 25, 2010 9:12:46 AM

Page 1

Item ID: D3852-041

Accept

Setup Start

Revision ID:

Stop

Item Name: Rib Assembly

Start Date: 8/25/2010 Start Qty: 2.00

Required Date: 9/1/2010 Req'd Qty: 2.00

Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Date: 10-8-25 Tooling:

Date:

QC:

Date: SPC (Y/N):

Date:

Run Start

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D3852

Rev A

100

0.00



Large Fab

Large Fab

Memo

0.00

Large Fab

1- pick D3166-3 to cut D3852-1 rib (LH) as per dwg D3852 using DT9440 jig

2- drill hole (3/16") in D3852-1 using DT9439 jig and open to finish size as per dwg D3852

3- c/sink hole as per dwg

4- remove identification markings

5- deburr

6- weld D3759-1 bushing as per dwg D3852

A/R ER316 S.S. Rod Batch: M114649

7- grind bushing weld flush as per dwg dwg D3852 ✓

8- deburr hole if necessary ✓

MS 10/09/16 (42)

SAD 10-09-09

①

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____




NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			



NOTE: Date & initial all entries




Work Order ID 61433

Wednesday, August 25, 2010 9:12:46 AM

Page 2

Item ID: D3852-041 Accept  Setup Start 
Revision ID: Stop 
Item Name: Rib Assembly
Start Date: 8/25/2010 Start Qty: 2.00  Cust Item ID:
Required Date: 9/1/2010 Req'd Qty: 2.00  Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start 
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop 

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130  QC Quality Control	QC9- Inspect visual per QSI004- Fusion Welds Memo	0.00 0.00				<u>10.09.21</u>			
140  QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00		<u>8/10/09/21</u>		<u>(40)</u> <u>204</u>			
150  Packaging Packaging	Identify as per dwg & Stock Location: _____ <u>Basket coll</u> Memo	0.00 0.00				<u>10/09/22</u>			<u>(40)</u>

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Work Order ID 61433

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Page 3

Item ID: D3852-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Rib Assembly

Start Date: 8/25/2010 Start Qty: 2.00



Cust Item ID:

Required Date: 9/1/2010 Req'd Qty: 2.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/09/22

CL 10/9/22

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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NOTE: Date & initial all entries

Picklist Print

Wednesday, August 25, 2010 9:12:50 AM

Page 1

Work Order ID: 61433

Parent Item: D3852-041

Parent Item Name: Rib Assembly



Start Date: 8/25/2010

Required Date: 9/1/2010

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP Rev:A 08-12-02 new issue DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D3166-3		Manufactured	No			100	Each	5.0418	0.18	0.378947			
---------	--	--------------	----	--	--	-----	------	--------	------	----------	--	--	--



Basket Hoop



Location

Loc Qty

Loc Code

WA

5.041821053

55697

2.1053E-05

59266

0.0418

60270

5

D3759-1

Manufactured No

100

Each

91.0000



Bushing

Location

Loc Qty

Loc Code

ST084

60

56942

60

WA

31

54072

9

61348

22



SAD

10-09-09

total

0.3789

0.3789

0.3789

2

10/09/16

24x

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

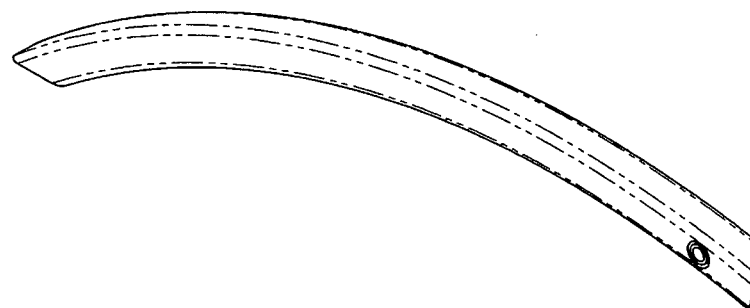
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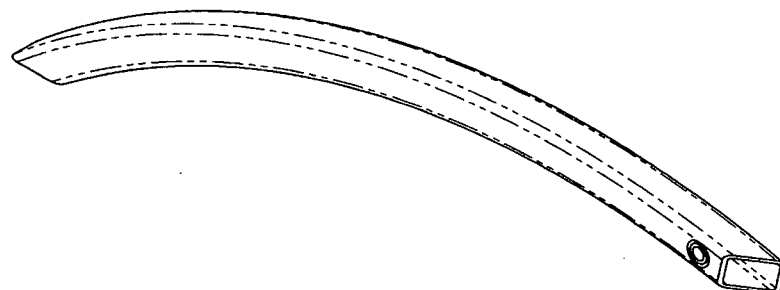
NOTE: Date & initial all entries

8 7 6 5 4 3 2 1

ITEM	QTY -041	QTY -042	P/N	DESCRIPTION
1	X		D3852-041	RIB ASSEMBLY
2		X	D3852-042	RIB ASSEMBLY
3	1	1	D3759-1	BUSHING
4	1		D3852-1	RIB
5		1	D3852-2	RIB



D3852-041 RIB ASSEMBLY



D3852-042 RIB ASSEMBLY

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 61433
BS10-F-25

RELEASE
08/11/07 MP

- NOTES:
- 1) MATERIAL: N/A
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 0.83 lbs EACH
 - 8) WELDING: PER QSI 004

A	NEW ISSUE	MB	08.11.07
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	08.11.07		

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. **D3852** REV. A
TITLE **RIB ASSEMBLY** SCALE NTS
SHEET 1 OF 3

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8 7 6 5 4 3 2 1

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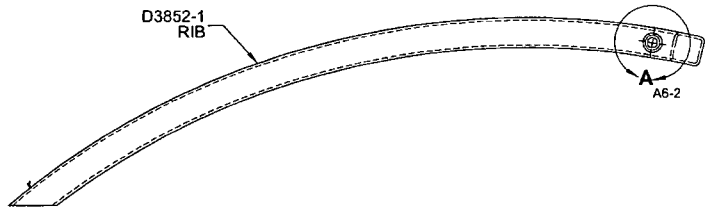
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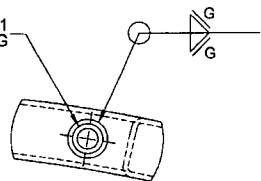


D3852-1
RIB



D3852-041 RIB ASSEMBLY

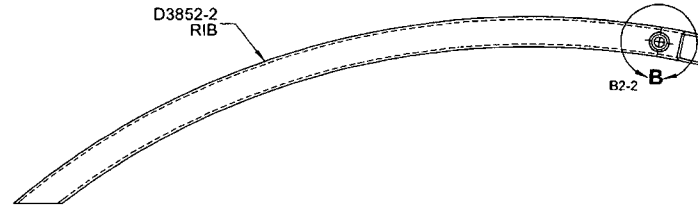
D3759-1
BUSHING



DETAIL A
SCALE 2X C5-2

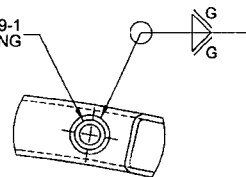


D3852-2
RIB



D3852-042 RIB ASSEMBLY

D3759-1
BUSHING



DETAIL B
SCALE 2X C2-2

w/o 41433

RELEASED
08/11/15

DESIGN		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN			
CHECKED	185		
MFG. APPR.			
APPROVED			
DE APPR.		DRAWING NO.	REV. A
		D3852	SHEET 2 OF 3
		TITLE	SCALE
		RIB ASSEMBLY	NTS
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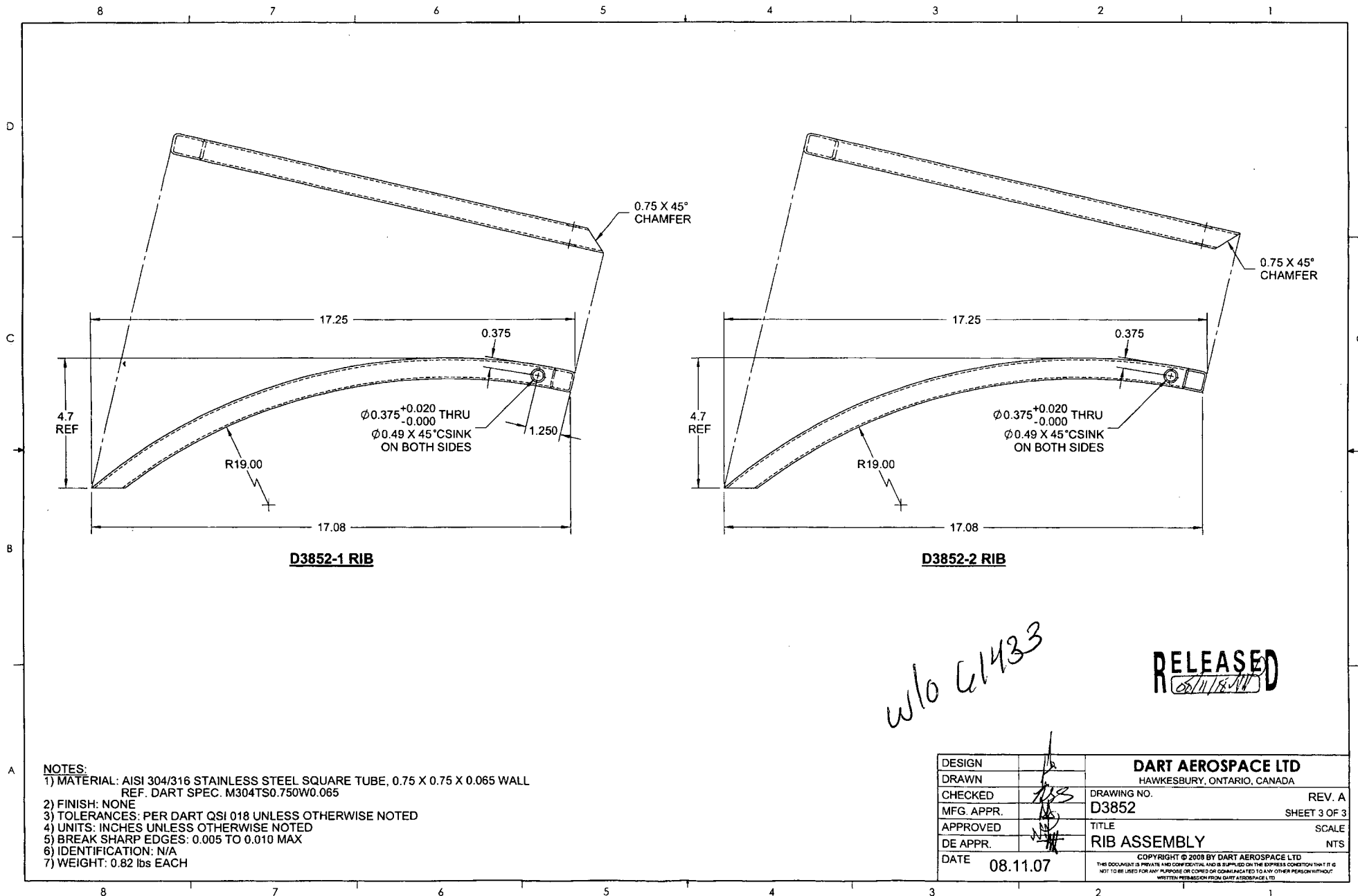
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